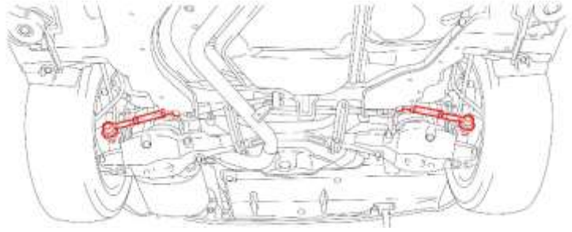
SAFETY RECALL GLK
HS250h Rear Lower Suspension Arm No.1 Replacement

1. REPLACE RH AND LH REAR SUSPENSION ARMS

- Replace both the LH and RH Rear Lower Suspension Arm No.1.
- Replace the both the mounting bolt and nut securing the rear lower suspension arm to the suspension member.
- *Always hold the nut and turn the bolt when torqueing.*



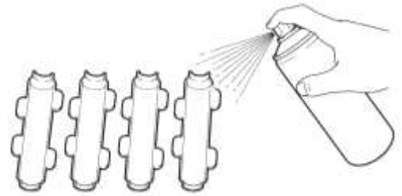
2. PERFORM FOUR WHEEL ALIGNMENT

- Jounce the front & rear of the vehicle to settle the suspension with vehicle on the alignment rack slide plates and the pins removed.
- Ensure the ball joint is aligned correctly before tightening lock nuts.
- *DO NOT* move the adjusting tube when tightening the lock nuts.
- Torq. the lock nuts using the SST and follow the specific sequence.
- Failure to follow this procedure *EXACTLY AS DESCRIBED* could cause the arm to become loose.

Tools: Rear Control Arm Torq. Fixture, 22mm Crowfoot, Torque Wrench

3. PREPARE MOLDS

- Confirm the molds are clean.
- Apply 2 coats of mold release, allow ~60 seconds dry time.
- Mold release should not be wet or pooling after drying time.



4. CLEAN SUSPENSION ARM

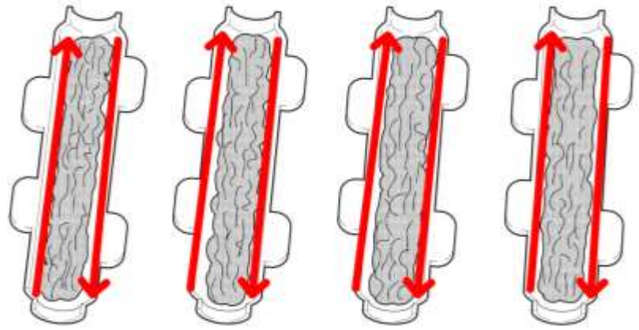
- Clean the exterior surface of the new arms with brake clean.
- This is *CRITICAL* to confirm the epoxy adheres properly.

5. PREPARE EPOXY

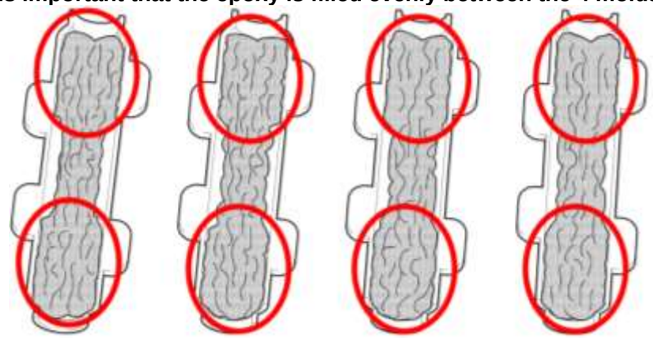
- Start by filling the mixing nozzle to the tip by squeezing the applicator handle, then releasing it when full.
- Pre-filling the nozzle is *CRITICAL* to even epoxy distribution.

6. FILL THE MOLDS WITH EPOXY

- Follow step 6 *EXACTLY*, so there are no voids in the epoxy once set.
- Apply 2 full squeezes of the epoxy along the length of each mold.
- One epoxy cartridge contains approximately 12 full squeezes.

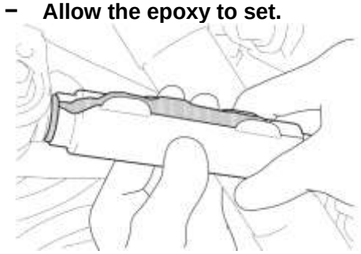


- Apply the remaining 3-4 squeezes in the upper and lower thirds.
- The epoxy has approximately 5 minutes of working time.
- It is important that the epoxy is filled evenly between the 4 molds.



7. INSTALL THE MOLDS

- Apply the molds over the lock nuts and adjusting tube.
- Press the molds together so that the epoxy is forced out along the parting lines.
- Allow the epoxy to set.

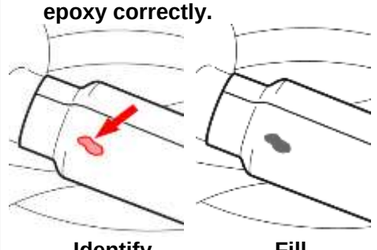


8. CLEAN/TRIM EPOXY

- Once set for a minimum of 30 minutes, remove the molds, *DO NOT* remove them early.
- Trim the excess epoxy.
- Wipe the epoxy using a clean shop cloth.

9. INSPECT EPOXY

- Inspect for voids that expose the arm, fill any voids with FIPG.
- There should not be any voids if the molds are filled with epoxy correctly.



Identify **Fill**

10. APPLY LABEL

- Confirm all mold release residue has been wiped off of the arm.
- Wrap the caution label around the epoxy, it is designed to overlap on itself by 3/8".

This document is intended as a technician aid. Carefully follow the complete GLK instructions found on TIS when performing this repair.